

Date: Sunday, 12/4/2005 12:45:00 PM  
 User: Linda Lacelle

Split

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: HI-STEP LEG ASSEMBLY
Job Number	: 25089 - 1		
Estimate Number	: 10355		
P.O. Number	: N/A	Part Number	: D2582
This Issue	: 12/4/2005	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: D2582 REV A
First Issue	: N/A	Project Number	: N/A
Previous Run	: 24533	Drawing Revision	: A
	Type : SMALL /MED FAB	Material	: N/A
Written By	: See comment below	Due Date	: 12/12/2005
Checked & Approved By	: See comment below	Qty:	19 20 Um: Each
Comment	: Est Rev:F Removed Manufacturing 05-11-07 JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	25089A	SPACER
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Comment: Sub-Component SPACER

2.0	25089B	STEP LEG
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Comment: Sub-Component STEP LEG

3.0	25089C	STEP SPACER
-----	--------	-------------



Comment: Sub-Component STEP SPACER

4.0	25089D	STEP SPACER
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Comment: Sub-Component STEP SPACER

5.0	D2279	Step Spacer
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 20.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2279	Spacer	B22585


6.0	D2278	Step Leg
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Comment: Qty.: 2.0000 Each(s)/Unit Total: 40.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	D2278	Leg	B250892

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
05/12/20	11	Stock 19	put in stock	2 D0075 2 D2280	SB	05/12/20	2		 05-12-20

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: PS Date: 06/01/04  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



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Job Number: 25089

Part Number: D2582

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

D2280

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 40.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D2280 Spacer B25089A

8.0

D2322

Step Spacer



Comment: Qty.: 1.0000 Each(s)/Unit Total: 20.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2322 Spacer (3) B19702A  
1 B 21865A  
1 B 21360  
9 B 23329

9.0

MS20470AD44

Rivet, Universal Head



Comment: Qty.: 22.0000 Each(s)/Unit Total: 440.0000 Each(s)

Pick:

Qty Part Number Description Batch

22 MS20470AD4-4 Rivet M17944

10.0

MS20470AD45

Rivet, Universal Head



Comment: Qty.: 4.0000 Each(s)/Unit Total: 80.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 MS20470AD4-5 Rivet M18491

11.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1  
Assemble as per Dwg D2582 and

SB 05/12/20 19

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

05.12.20 19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



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Job Number: 25089

Part Number: D2582

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

*205-12-28*

14.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

*545 06/01/06 19*

*DD 06/01/04*

Job Completion



W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



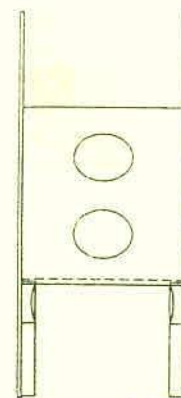
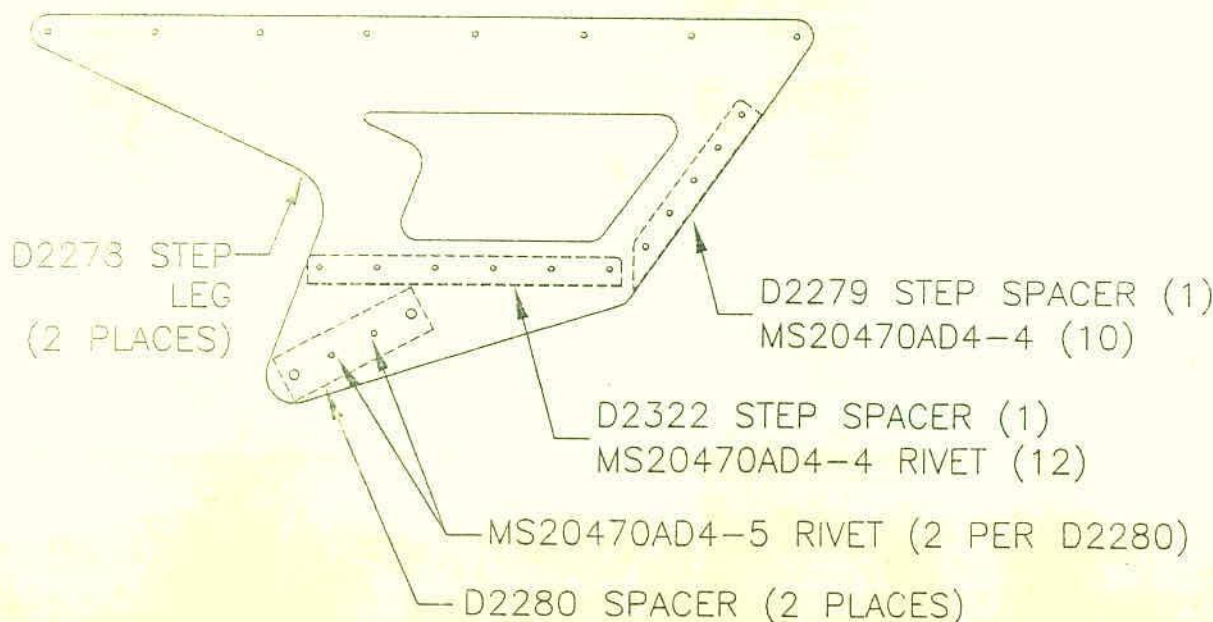
REFERENCE ONLY



DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2582	REV. A SHEET 1 OF 1
DATE 01.10.05		TITLE STEP LEG ASSEMBLY SCALE 1:5	
A	01.10.05	NEW ISSUE	

QTY	PART NUMBER	DESCRIPTION
2	D2278	STEP LEG
1	D2279	STEP SPACER
2	D2280	SPACER
1	D2322	STEP SPACER
22	MS20470AD4-4	RIVET
4	MS20470AD4-5	RIVET

CONTROLLED COPY



D2582

RELEASED  
01-10-16 #

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